DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-024422
Date Inspected: 17-Jun-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1530
Location: Job Site

CWI Name:	Steve Jensen			**CWI Present:**	☑ Yes	☐ No	
Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Approved WPS:**	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: Tower

Summary of Items Observed:

This Quality Assurance (QA) Inspector, Craig Hager was on site at the job site between the times noted above. This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and monitor American Bridge/Fluor (ABF) welding operations. This Quality Assurance (QA) Inspector, Craig Hager observed the following.

Prior to the start of welding this QA Inspector observed an induction heating system consisting of either the air cooled blanket type or the liquid cooled hose type which appeared to have been positioned over the area to be welded in order to start the preheating process, gas troches are used to bring the preheat temperature to be within the range specified in the Welding Procedure Specification (WPS) as needed. At the completion of welding and/or at the end of the shift it appears the same induction heating system is used to perform the 3 hour post heating.

114 Meter elevation – West Tower – Splice Plates

This QA Inspector observed ABF welding personnel Salvador Sandoval (#2202) using the Flux Cored Arc Welding (FCAW) process to weld the vertical (3F) fillet welds on splice plate weld joint #166-West. This QA Inspector randomly observe d QC Inspector Steve Jensen verify the following welding parameters; 272 amperes and 20.5 volts at a travel speed of 118 mm per minute to produce a heat input of 2.84 Kj per mm. The welding observed appeared to comply with ABF-WPS-D15-2200-3. The welding at this location is being performed in a small space in which movements are limited. This QA Inspector observed ABF welding personnel Salvador Sandoval (#2202) using a hand held gas torch periodically to maintain the required minimum preheat temperature of 300° F.

During this QA Inspectors' shift welding was periodically observed in the West Towers this date. The progress of work appears to be slow due to the limited access for welding and grinding at all locations. This QA Inspector periodically observed QC Inspector Steve Jensen at this location monitoring the welding.

114 Meter elevation – North Tower – Splice Plates

This QA Inspector randomly observed ABF welding personnel Xiao Jian Wan (#9677) using a grinder to remove the various fit up aids from the splice plates in the North corner. This QA Inspector randomly observed ABF welding personnel Mike Jiminez (#4671) and Paul Frambrini in the process of fitting up the two splice plates in the Northeast corner.

114 Meter elevation – South Tower – Splice Plates – All QC and QA inspections have been completed.

Summary of Conversations:

This QA Inspector had general conversations with American Bridge/Fluor (ABF) and Caltrans personnel during this shift. Except as described above and noted below there were no notable conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Hager,Craig	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer